Work Orde				*124	509*							Page 1
Item ID: Revision ID:	D3642-1			Accept	*N900)040	100)*	Setup	Start	*N	S1*
Item Name:	Doubler									Stop	*N	S2*
	9/10/14	Start Qty: 6.00	*6*		Cust Item	ID:					- 4	
Required Date: Reference:	9/10/14	Req'd Qty: 6.00	*6*		Customer:	:						
Approvals:	Process P	lan:	Date:	Tooling:	D	Pate:	_		Run	Start	*N	R1*
	QC:				D	ate:				Stop		R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Re	evision Nbr			- 1-W							
D3642	Re	ev B										
100 *1 \\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\		FLOW WATER JET Memo		0.00		111		<u>(8)</u>			DC 14	10/19
FLOW CNC Waterje	t	1-Cut as per Deburr if ne	Dwg D3642 Dwg Rev: cessary	B Prog Rev: B	_ 2-							
110		QC2- Inspect parts off m	achine FAI/FAIB	0.00								
110 QC Quality Control		Мето		0.00				8		R	/ox 14/	10/14_
Quanty Control												
¹²⁰ *1 <i>つ</i> ∩*		QC8- Inspect parts - seco	nd check	0.00				(8))		9	AE 18 8° OCT 2 0 2
QC		Memo		0.00								<u> </u>

0.00

Memo

Quality Control

DQA:		Date:			WORK ORDER MON			DAMANCE / LIDDATE				`DART
QA Closed:		Date:			WORK ORDER NON-	-C(JNFOI	RIVIANCE / UPDATE	W	ork Order up	date only	AEROSPACE
		<u> </u>			DISPOSITION			AGAINS	T DE	PARTMENT	PROCESS	
Work Orde	r:		,								_	
					Rework		i	Skid-tube Crosstub	<u> </u>	ļ "	Water Jet	Engineering
Part N	o				Scrap			Machining Small Fa noforming Finishir		4	d. Eng. Coor. re/Packaging	Quality Other
NCR N	0				Use-as-is Suspected Unapproved		inern	noforming Finishir Large Fab Composit	~⊢	Kec/Stol	Supplier	
NCK IV	0				Suspected Onapproved			composit	· <u> </u>	.		
Root				Desci	ription of work order update	Ī	nitial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design												
Doc/Data		1										
Equip/Tooling												
Handling/Pre												
Material												
Operator												
Offset/Setup												
Process												
Supplier												
Training												
Transport					;							
Unapproved		<u> </u>	<u> </u>	<u></u>		<u> </u>						<u> </u>
						FAU	JLT CA	regory			· · · · · · · · · · · · · · · · · · ·	
Landin	g Gear				General	_	l			Outside Dim	:	Pressure/Forced
-	Bending				Bend	<u> </u>	1	Program	-		<u> </u>	Set-up
-	Centre N	ot Conce	ntric		BOM/Route		Grain		\vdash	Over/Under	<u> </u>	Temperature/Cure
-	Cracks			-	Broken/Damage/Defect		Hardwa		<u> </u>	Part Incorred	 	Weld
-	Crimp/Kii	nk/Ripple	e/Wave	-	Burrs	_	'	ion Incomplete/Unqualified	\vdash	Part Lost/Mi Part Moved	ssing –	╡
}	Cuffs			\vdash	Countamination	_	1	tions Incomplete/Unclear	\vdash	Part Moved Positioned V	/rong	Wrong Stock Pulled
}	Crushing			\vdash	Countersink		1	gned/off center	-	Power Loss/		Other
}	Heat Trea		Tuba	-	Cut Too Short	 	Mislabe Misreae		L	Thomes ross	ourge [Totalei
}	Inspectio	•	eauı	-	Drawing Drill Holes	\vdash	Off-set					
}	Marks/Ch Turning S			\vdash	Finish	\vdash	ł	Calibration				
}	Wave/Tw			\vdash	Fit/Function		•	Sequence				
	[vvave/IW	vist iii TUI	u c	- 1	programenon	L_	Juc or .	Jequence				

Work Ord September-11-				*124	*124509*								
Item ID: Revision ID: Item Name:	D3642-1 Doubler			Accept	*N900	0040	100)*	Setup	Start Stop	*N.	S1* S2*	
Start Date: Required Date Reference:	9/10/14 e: 9/10/14	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item Customer:								
Approvals:	Process P. QC:	lan:	Date:	Tooling: SPC (Y/N):	74465	ate:		1	Run	Start Stop		R1* R <i>2</i> *	
Sequence ID/ Work Center 1 130 *120* HandFinish Hand Finishing	ID	Operation Description Chemical Conversion Co	pat per QSI005 4.1	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
140 *140* QC Quality Control		QC3 inspect Part Finish Memo		0.00				8	· · · · · · · · · · · · · · · · · · ·			DAS 38 989 OCT 2 1 20	
150 *1 \(\) Packaging		Identify as per dwg & Sto	ock Location: St-054	0.00				<u>(§</u>	_14	1/10/2	<u> </u>	DAS 46	

Packaging

DQA:			. Date:			·							<u> </u>	DART
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UF		ork Order up	odate only	٦	AEROSPACE
Q 1 01000 Q						DICOCCITION				ACAINST D	EPARTMENT	/DPOCESS	· · · · ·	
Work Orde	er:					DISPOSITION				AGAINST D	- -	/FROCE33		
	•					Rework			Skid-tube	Crosstube	_	Water Jet	_ €	ngineering
Part N	۷o.					Scrap			Machining	Small Fab	┥	d. Eng. Coor.	_	Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	4	Other
NCR I	۷o. _.					Suspected Unapproved			Large Fab	Composite		Supplier		
Root					Desci	ription of work order update	<u>_</u>	L Initial	Acti	ion	Sign &			
Cause	l	Date	Step	Qty		or non-conformance	ı	ief Eng	Descr	iption	Date	Verification	ŀ	QC Inspector
Design								<u>y</u> .				· 		
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material							ĺ					:		
Operator														
Offset/Setup														
Process														
Supplier													1	
Training														
Transport									:					
Unapproved			<u> </u>				<u>L_</u>							
, ,							FA	ULT CAT	regory					
Landi	ng (ı			. —	General		1		_	٦	. г		/- 1
		Bending			-	Bend	<u> </u>	-	Program	_	Outside Dim	F	_	essure/Forced
		Centre N	ot Concer	ntric		BOM/Route		Grain		<u> </u>	Over/Under	F	_	t-up
		Cracks	_		<u> </u>	Broken/Damage/Defect	L	Hardwa		<u> </u>	Part Incorre			mperature/Cure
		Crimp/Kii	nk/Ripple	/Wave	-	Burrs	_	4 '	ion Incomplete/Un		Part Lost/Mi	ssing	$ \begin{bmatrix} w_{\epsilon} \\ w_{\epsilon} \end{bmatrix}$	
		Cuffs			<u> </u>	Contamination	\vdash	_	tions Incomplete/U	unciear	Part Moved	L	w	ong Stock Pulled
		Crushing			<u> </u>	Countersink	-	-1	gned/off center	_	Positioned V		٦٠٠	her
	\vdash	Heat Trea			<u> </u>	Cut Too Short	<u> </u>	Mislabe		<u></u>	Power Loss/	ourge [Jou	1101
	<u> </u>	Inspectio		Tube	-	Drawing	-	Misread						· 5.00.
	_	Marks/Ch			-	Drill Holes	\vdash	Off-set						
		Turning S				Finish	\vdash	-	Calibration					
		Wave/Tw	vist in Tub	e		Fit/Function		Out of :	Sequence					

Work Order ID 124509 *124509* Page 3 September-11-14 12:07:54 PM D3642-1 Item ID: Accept *N900040100* Setup Start **Revision ID: Item Name:** Doubler 9/10/14 **Start Date:** Start Qty: 6.00 **Cust Item ID:** Required Date: 9/10/14 **Req'd Qty:** 6.00 **Customer:** Reference: Start Run **Approvals:** Process Plan: Date: **Tooling:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID Description Run Hours** Code Qty Number Stamp Qty, 160 QC21- Final Inspection - Work Order Release 0.00 *160*

0.00

Memo

QC

Quality Control

M4-10-21

DQA:			_ Date:						•					TRACT
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDA		101	1.4 F		AEROSPACE
QA Closed:			Date:							Wo	ork Order up	date only		
Work Ord	er.					DISPOSITION			A	GAINST DE	PARTMENT	PROCESS		
WOIK OIG	٠, .					Rework			Skid-tube Cr	osstube		Water Jet		Engineering
Part I	No.					Scrap			—	mall Fab	Prod	d. Eng. Coor.		Quality
	•				_	Use-as-is		Thern	noforming F	inishing	Rec/Stor	e/Packaging		Other
NCR I	۷o.					Suspected Unapproved			Large Fab Co	mposite		Supplier		
Root					Desc	ription of work order update		nitial	Action		Sign &			· · · · · · · · · · · · · · · · · · ·
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descriptio	ń	Date	Verification	1	QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material		•												
Operator													,	
Offset/Setup														
Process														
Supplier														
Training														
Transport														
Unapproved	L							W T 6 4 5	TECODY					
							FA	ULI CA	TEGORY					· · · · · · · · · · · · · · · · · · ·
Landi	ng (General		احمانمات	Program		Outside Dim	ensions [Pressure/Forced
:	⊢	Bending	at Canaca	.+	.	Bend BOM/Route	-	Grain	rogram		Over/Under	-		Set-up
		Centre No	or concer	ittic	\vdash	Broken/Damage/Defect	\vdash	Hardwa	aro		Part Incorrec	F		Temperature/Cure
	-	Cracks Crimp/Kir	nk/Binnlo	/\\/\	-	Burrs		4	ion Incomplete/Unquali		Part Lost/Mi	· · · · · · · · · · · · · · · · · · ·		Weld
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	\vdash	Heat Trea				Cut Too Short	\vdash	Mislabe	=		Power Loss/S			Other
		Inspectio		Tube		Drawing		Misrea		L	1	- L		
		Marks/Ch				Drill Holes	-	Off-set				· · · · · · · · · · · · · · · · · · ·		
		Turning S				Finish		4	Calibration					
		Wave/Tw				Fit/Function		Out of	Sequence					

Picklist Print

September-11-14 12:07:54 PM

Work Order ID: 124509

124509

Parent Item:

D3642-1

D3642-1

Parent Item Name: Doubler

Start Date: 9/10/14

Required Date: 9/10/14

Start Qty: 6.00

**

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 07-07-20 JLM

Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M2024T3S.050	•	Purchased	No			100	sf	89.8911	0.1664	2				

M2024T3S 050

2024-T3 .050 sheet

Location Loc Oty Loc Code MAT022 89.8911 37.2911 m128354 42.2 m128713 10.4

DQA:			Date:										`	TRAGC"
						WORK ORDER NON	-CC	ONFO	RMANCE / UP					AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
Mante Onda						DISPOSITION				AGAINST DI	EPARTMENT,	/PROCESS		
Work Orde	-		-			Rework	1		Skid-tube	Crosstube	7	Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab	-	d. Eng. Coor.		Quality
NCR N	lo.					Use-as-is Suspected Unapproved]	Inerr	noforming Large Fab	Finishing Composite		re/Packaging Supplier		Other
Root					Desc	ription of work order update		Initial	Acti	on	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification		QC Inspector
Design									ļ					
Doc/Data							l		ĺ					
Equip/Tooling	_													
Handling/Pre														
Material													- 1	
Operator													-	
Offset/Setup	_													
Process	_													
Supplier														
Training	_													
Transport	_													
Unapproved			<u>i </u>	<u> </u>	<u> </u>				FECORY					
							FA	ULI CA	TEGORY			***		
Landir [General]/r	Program	Г	Outside Dim	onsions [\neg	Pressure/Forced
}		Bending	- t C		-	Bend BOM/Route		Grain	riogiaili	<u> </u>	Over/Under			Set-up
}		Centre No	or concer	ILTIC		Broken/Damage/Defect	-	Hardwa	aro.	-	Part Incorred	-	_	Temperature/Cure
	$\overline{}$	Cracks	nk/Binnlo	Mayo		Burrs	\vdash	4	ion Incomplete/Un	qualified	Part Lost/Mi	F	_	Weld
	-	Crimp/Kir Cuffs	пк/кірріе	/ wave	-	Contamination	-	4 '	tions Incomplete/U	· —	Part Moved	-	-	Wrong Stock Pulled
					\vdash	Countersink		4	gned/off center	- Inclear	Positioned V	L Vrong		wrong stock runeu
		Crushing Heat Trea			-	Cut Too Short	-	Mislabe	-		Power Loss/		\neg	Other
	_	Inspectio		Tubo	-	Drawing	\vdash	Misrea			J. 5c. 2533/			
	$\overline{}$	Marks/Ch		Tube		Drill Holes		Off-set						
	\dashv	Turning S				Finish	\vdash	-1	Calibration					
	-	Wave/Tw			-	Fit/Function	\vdash	4	Sequence					
							1	1	<u> </u>					

DART AEROSPACE LTD	Work Order:	124509
Description: Doubler	Part Number:	D3642-1
Inspection Dwg: D3642 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	Tolerance	Dimension	Ассері	Reject	Inspection	Comments
Ø0.125	+0.004/-0.001	125	/		V=5kM-01	
Ø0.098	+0.004/-0.001	· 698	_		T=Jkm-cl	
0.35	+/-0.030	.35	ن			
1.25	+/-0.030	1-25	7			
1.700	+/-0.010	1.700	/			
2.15	+/-0.030	2-15	_			
3.05	+/-0.030	3.05	_			
3.95	+/-0.030	3.95				
4.078	+/-0.010	4.075	_			
4.85	+/-0.030	4.85	1			
5.20	+/-0.030	5.20	_			
0.343	+/-0.010	. 34 >	_			
0.40	+/-0.030	. 40	_			
1.30	+/-0.030	1.36	_			
3.35	+/-0.030	3.35	-			
3.47	+/-0.030	3.47	_			1
3.79	+/-0.030	3.79	-			
3.959	+/-0.010	3.959	_			
4.08	+/-0.030	4-08	/			
4.60	+/-0.030	4.60				
1.537	+/-0.010	1.537				
3.28	+/-0.030	228	~			
3.80	+/-0.030	3.80				
3.915	+/-0.010	3,915				
0.450	+/-0.010	1450				
4.066	+/-0.010	4.066	_			
4.20	+/-0.030	4.20	10AS			

Measured by: De/R	Audited by:	9-89	Prototype Approval:	N/A
Date: /4/10/19	Date:	OCT 2 0 2014	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.10.19	New Issue	KJ/EC/DD 1.A	
В	08.12.01	Dimensions updated per Dwg Rev. B	KJ/EC	

R0.25 (TYP) 5.20 4.85 Ø0.125 (4 PLACES) 4.078 3.915 3.95 3.80 3.28 3.05 Ø0.098 THRU (TYP) 2.15 1.700 1.537 1.25 0.35 3.35 3.47 3.79 3.959 4.08 4.60 0.40

D3642-1 DOUBLER (WAS GENEVA P/N G10607-1/-2)

D

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 174509 MLJ 14-09-18

REMOVE -2; UPDATE -1 TO INCLUDE G10607-2 LE 07.10.16 NEW ISSUE; REPLACES G10607 LE 07.07.27 Α DESCRIPTION DATE REV. BY DESIGN DART AEROSPACE USA, INC. DRAWN PORT HADLOCK, WA DRAWING NO. CHECKED REV. B D3642 MFG. APPR. SHEET 1 OF 1 APPROVED TITLE SCALE **DOUBLER** 4:5 DE APPR. DATE 07.10.16

NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T35.050)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3642-1" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.11 lbs

D

С

В

3

8